Work Orde <i>July 14, 2009 16</i>											Page
Start Date:	D2175-2 E Angle RH 7/15/09	Start Qty: 10.00		III I I I I I	Cust Item I	D :		S S	Setup S		
Required Date: Reference:	7/13/09	Req'd Qty: 10.00			Customer:						
Approvals:	Process	Plan: MF	Date: <u>09- 07</u> -	15 Tooling:	Da	ate:		F		***************************************	
	QC:	·	Date:	SPC (Y/N):	Da	ate:			S	top	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	J	Revision Nbr									
D2175	·	Rev E									
100		FLOW WATER JET		0.00							
Waterjet FLOW CNC Waterje	et	Memo 1-Cut as per Deburr if ne	Dwg D2175 □Dwg l cessary	0.00 Rev:E∏Prog Rev:	<u>E</u>	iB 9	ı-7-3	6	\overline{Z})	
110 Libbiri Harri Hari Bahi Bahi Irri		QC2- Inspect parts off m	achine FAI/FAIB	0.00		HBC	}- ∀-7	ر د			

QC

0.00

Quality Control

120

QC

Quality Control

Memo

QC8- Inspect parts - second check

Memo

26/20/20 C = 00.0

Page 1

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES Approval Approval** DATE **STEP PROCEDURE CHANGE** By Qty Date Chief Eng / QC Inspector Prod Mar Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval DATE** Approval STEP Sign & Initial **Action Description** Section A Section C QC Inspector Chief Ena Chief Eng Date Chief Eng

H-WFORMS\Quality Assurance\approved QA\NCRWO RevE

July 14, 2009 10:27:36 AM

Item ID:

D2175-2

Ε

Revision ID: Item Name:

Angle RH

Start Date:

7/15/09

Required Date: 7/15/09

Start Qty: 10.00 Req'd Qty: 10.00



Accept

Setup Start

Stop

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: _____

Tooling: Date:

SPC (Y/N):

Date:

Date:

Run

Start



Stop

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/ **Run Hours**

Number

Draw

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Brake NC

Brake NC

140

NC BRAKE

Memo

Memo

Form as per Dwg D2175

0.00

So 09/07/22

12 8

150

Quality Control

QC5- Inspect part completeness to step on W/O

22 Porlal 22

Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			····					
			· · · · · · · · · · · · · · · · · · ·					
Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes !	No DQA:	Date: _	
		solution:						
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR			
DATE	STEP	Description of NC			tion B	Verification	Approval	Approval
	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
				·				

Page 3

July 14, 2009 10:27:36 AM

Item ID:

D2175-2

Е **Revision ID:**

Item Name: Angle RH

Start Date: 7/15/09

Start Qty: 10.00

Req'd Qty: 10.00

Accept



Setup Start

Stop



Required Date: 7/15/09



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC: _____ Date:

Date: Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop



Sequence ID/ **Work Center ID**

160

HandFinish

Operation Description

Chemical Conversion Coat per OSI005 4.1

Set Up/ **Run Hours**

Draw Number

St 09-07-33

Draw Plan Rev.

Code

Accept Reject Qty_ Qty

Reject Insp. Number Stamp

0.00

Hand Finishing

170

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

180

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

83 09/07/23 (12



Memo

Dart Aerospace Ltd

		- 							
W/O:			WO	RK ORDER CHANG	GES		·		
DATE	STEP	PR	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							:		
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	
		solution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	?)			
DATE	STEP	Description of NC			tion B	Verifi	cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector

Work Order ID 50230

July 14, 2009 10:27:36 AM



Page 4

Item ID:

D2175-2

Accept

Setup Start

Stop

Revision ID:

Angle RH Item Name:

Ε

7/15/09 Required Date: 7/15/09

QC:

Start Qty: 10.00

Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Operation

Description

Date:

QC21- Final Inspection - Work Order Release

Date:

Tooling:

SPC (Y/N):

Set Up/

Date: Date:

Draw

Number

Run Start

Stop

Sequence ID/ **Work Center ID**

190

Memo

Run Hours

0.00

Draw Rev.

Plan Code

Reject Accept Qty Qty

Reject

Insp. Number Stamp

Quality Control

0.00

09607127424 MF 09-07-24

Dart Aeros	pace Ltd
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	Jopaso									
W/O:			WC	RK ORDER CHANG	iES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: `	Yes N	o DQ	A:	Date:	
	R	esolution:	Disposition	າ:	_ QA: N/	C Clos	sed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (N	VCR)				
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti		Chief Eng	QC Inspector
									.,	
l										

[·] H:\#FURMS\Quality Assurance\approved QA\NCRWO RevE

Picklist Print

July 14, 2009 10:27:36 AM

Work Order ID: 50230

Parent Item:

D2175-2RevE

Parent Item Name: Angle RH



Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 10.00

Qty

Required Qty: 10.00

			–				
Co	mĮ	on	ient	Ite	m	ID	/
Ite	m	Na	me				

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location

Last Location Route Seq ID Unit of

sf

Qty on Measure Hand

Remaining Qty To Pick Issued Date Issued Status

M2024T3S.063

Comments:

Purchased

No

100

163.2716 4.9705

<u>Warehouse</u>	Loc Oty	Loc Code	
Location			
Main Warehouse			
MAT	163.2715789		
102942	1.5		(12
105916	3.69		
106223	1.47		
109463	24.2		
110980	15.45		110980 189-7-22
111787	114.961579		<u></u>
19059	2		

Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A :	Date:	·
	Reso	olution:	Disposition	:	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific		Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector
······································									
						1			

[・] H:\持令RMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	50,030
Description: Angle	Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	13.650	Q			
R0.35	+/-0.030		K			
2.915	+/-0.010	2,918	×			
50°	+/-0.5°	200	\$			
0.300	+/-0.010	,385	Q	,		
1.050 Pitch	+/-0.010	1,649	×			
10.500	+/-0.010	10.493	84			
11.550	+/-0.010	11.548	4			
0.550	+/-0.010	(<48	æ			
0.900	+/-0.010	906	×			
0.063 thick	+/-0.010	,063	x			
Grain Direction	N/A	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	×			
Ø0.128	+0.005/-0.001	ıBI	يلا			
Ø0.172	+0.005/-0.001	,174	x			
	- 1 11,					

Measured by:	B	Audited by:	2	Prototype Approval:	N/A
Date:	4-7-35	Date:	05/09/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.08.12	New Issue	KJ/JLM , ,	1
В	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	Cidl

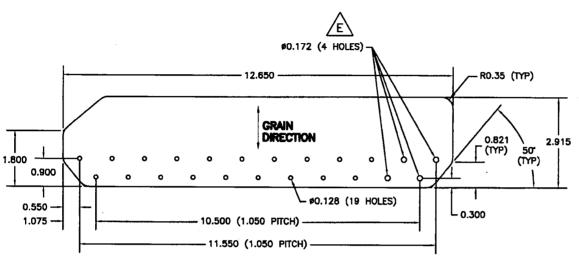


RO.16

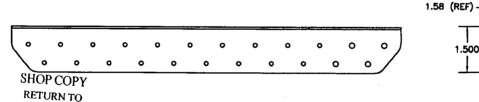
1.500

8 0 \Box \rightarrow .09.25 06.09.25 04.06.03 96.01.18 95.10.25 00.09.11 ANGLE D2175 DRAWING UPDATE Z NEW ISSUE RE-DESIGN CHANGED DIMENSION HOLE FINISH DIA 딩 SPEC ø0.172, 4 HOLES SHEET

--유 SCALE



D2175-1F FLAT PATTERN



ENGINEERING UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE WORK ORDER

NO.50230

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DOCUMENT

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DART AEROSPACE
ESS CONDITION THAT IT IS
WRITTEN PERMISSION FROM

NOT TO BE USED I

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PURPOSE

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COPIED

NOTES: MF 09-07-15

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)

D2175-1 BEND DETAIL SHOWN

(D2175-2 BENT OPPOSITE)

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- BREAK ALL SHARP EDGES 0.005 TO 0.010
- ALL DIMENSIONS ARE IN INCHES